



DEFENSE LOGISTICS AGENCY

AMERICA'S COMBAT LOGISTICS SUPPORT AGENCY



Small Arms Quality Initiative

WARFIGHTER SUPPORT ENHANCEMENT

STEWARDSHIP EXCELLENCE

WORKFORCE DEVELOPMENT



Introduction



- Small Arms Sourcing Initiative established January, 2013 to investigate persistent and ongoing problems with products in FSC 1005. Later expanded to FSC's in "Small Arms"



Project Activities



- Two main general problem areas identified:
 1. Phosphate coating failures
 2. General quality failures of parts from several Small Arms FSC's.
- Acquisition documents such as MIL-DTL-16232 and service controlled drawings were reviewed.
- Team performed several information-gathering visits to prime contractors for the subject parts.



Problems



Phosphate Coated Parts

- Current practice at DLA is to perform a pre-production review of phosphate coating procedures (lasting up to 90 days). Procedures are supplied for either the prime contractor if they are directly performing the work or their subcontractor for the coating as applicable.
- The team evaluated ~1600 reviews and was able to find very few instances where procedures were rejected for technical reasons.



Problems



Phosphate Coated Parts

- There is no pre-certification or qualification of phosphate coaters currently required by DLA. Extensive duplication of effort as phosphate coating procedures are reviewed on a contractual basis.
- Few checks in place that are working to ensure that phosphate coating procedures are actually reflective of the work being performed by the contractor.



Problems



Small Arms Parts, General

- There is no pre-certification or qualification of prime contractors currently required by DLA.
- Companies may bid on contracts and then find they lack the capability to perform the required work.
- Long acquisition lead times and backorders result from bids being awarded to companies without the manufacturing knowledge or quality underpinning to make the parts.
- Subject FSC's are: 1005, 1010, 1015, 1025, 1055 and 1095



Recommendations



Phosphate Coated Parts

- Require all companies, either prime contractors or their subcontractors, who intend to apply phosphate coatings to the subject parts, to attain Nadcap certification for Chemical processing.
- 6 month grace period from announcement of requirement to allow companies to achieve certification
- DLA will cease pre-production review of phosphate coating procedures.



Nadcap Certification

- Nadcap is a quality certification standard managed by the Performance Review Institute (PRI), and it is targeted towards specific processes.
- Widely used industrial standard. Many companies already hold certification. DLA has observed reduced failure rates for Nadcap-certified companies.
- Certification performed by PRI-accredited and controlled auditors. Cost: \$4875-\$6235 (Estimated)
- **www.pri-network.org/nadcap**



Recommendations



Small Arms Parts, General

- Implement a Qualified Suppliers List (QSL) program for prime contractors supplying parts in several FSC's (1005, 1010, 1015, 1025, 1055 and 1095).
- QSL program to be modeled after existing DLA and TACOM qualification programs
- Initial implementation in two phases. Initial phase addresses most critical items (drawn from FL top 1000 backorders).
- QSL program will contain an audit component, quality system requirement and list a defined process for contractor companies to be added to and removed from the QSL.



Conclusion



- **Current acquisition process for small arms parts contributes to long acquisition lead times and extensive backorders.**
- **Recommendations for change**
 1. Nadcap certification requirement
 2. Ending pre-production phosphate coating procedural reviews
 3. Establishing a QSL for small arms parts